Work Orde Monday, Decem				*949	วก7*				X	384	Page 1
Item ID: Revision ID:	D3933-1			Accept	*N900	040	100)* s	etup Star	IA	S1*
Item Name:	Aft Wall Prote	ector							Sto	° *N	S2*
Start Date: Required Date: Reference:	12/24/2012 1/3/2013	Start Qty: 3.00 Req'd Qty: 3.00	*3* *3*		Cust Item I Customer:	D:					
Approvals:		n: MF	Date: <u> </u> 2- 2-2 Date:	Tooling: SPC (Y/N):		ate:	- -	R	kun Stai Sto	" [\]	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3933	A										
100				0.00					·· ····		
100 Waterjet FLOW CNC Waterj	et	Memo 1-Cut as pe Dwg Rev:_ Prog Rev:_ 2- Deburr if		0.00				(3)		B	13-1-3
*110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00				(2)			2 2-3
QC		Mamo		0.00				(-)			B13-1-3

Quality Control

			DQA:	Date:	
					
JCR.	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

		•									QA Closed:	Da	te:	•
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	.,	
Part 1	•					Rework Scrap		1	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.		ngineering Quality
NCR 1	No.					Use-as-is Work Order Update	<u> </u>		noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	\blacksquare	Other
Root					Descri	ption of work order update	Ini	tial	Act	tion	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Chie	f Eng	Desci	ription	Date	Verificatio	n	QC Inspector
Doc/Data						,								
Equip/Tooling							ļ							
Operator	Ш	:					·						*	•
Material														
Setup	Ш													
Other													}	
Process	Ш													
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Training	Ш													
Unapproved							<u> </u>							
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Landi	$\overline{}$					General				_	7		_	
]		Bending				Bend	\vdash	irain		<u> </u>	Ovalized		⊢—	essure/Forced
	-	Centre No	ot Concer	ntric to	o/s	BOM/Route	\vdash	ardwa		<u> </u>	Over/Under		_	mperature/Cure
	\vdash	Cracks				Broken/Damaged	\mathbf{H}		ion Incomplete		Part Incorre		Щw	
	_	Crushed/0	Crimped.		<u> </u>	Burrs	\vdash		ions Incomplete/	Unclear	Part Lost/M	issing	∐Wı	rong Stock Pulled
	-	Cuffs				Contamination	\vdash		enance	<u> </u>	Part Moved			
	-	Heat Trea				Countersink	—	∕islabe			Positioned V			
	-	Inspection	•	Tube		Cut Too Short	\vdash	/lisread	d .		Power Loss/	Surge	Ot	her
	Ш	Ripples in				Drill Holes	\vdash	Offset						
	Ш	Torque W			ո _	Drawing	-		Calibration					
	-	Turning S				Finish		out of S	Sequence					
		Wave/Tw	ist in Tub	e	1	Folio		utside	Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde Monday, Decem					*(34 0	<mark>ን</mark> በ7*								Page	2
Item ID: Revision ID: Item Name:	D3933-1 Aft Wall Prote	ector			Accept		*NC	የበበ	040	1100)*	Setup	Start Stop	*N;	S1*	
Start Date: Required Date: Reference:	12/24/2012 1/3/2013	Start Qty: 3.00 Req'd Qty: 3.00		*3* *3*				t Item I tomer:	D:					10.		
Approvals:		in:				N):			ite:	- 		Run	Start Stop	17	R1* R2*	
Sequence ID/ Work Center II 120 *120* QC Quality Control)	Operation Description QC8- Inspect parts - secondary Memo	and check		0.00	Iours		ol ID	Tool#	Plan Code	Accept Qty	t Re Qt		Reject Number	Insp. Stamp	-
*130 *130* Packaging Packaging		Identify as per dwg & Sto	ock Locatio	n:	0.00	6 56	વ ન૧૦૦				3		— 	13/0	(103	O S
140 *140* QC Quality Control		QC21- Final Inspection -	Work Orde	r Release	0.00						·	M.I	L J	13-6	51-0	14
·												,	Q	13-1	H	

												DQA:	Date	e: _	
NCR:	Yes	/ No				WORK ORDER NON-C	ON	FOR	MANCE / UP	DATE		•		_	
							٠					QA Closed:	Date	e:	
Work Orde	er:				;	DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
Part N	-			1	***	Rework Scrap		1	Skid-tube Machining	Crosstube Small Fab		Proc	Water Jet d. Eng. Coor.	\exists	Engineering Quality
NCR N	۷o		· · · · · · · · · · · · · · · · · · ·			Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier]	Other
Root					Descri	ption of work order update	lr	nitial	Ac	tion		Sign &		Т	
Cause		Date	Step	Qty	C	or Non-conformance	Chi	ef Eng	Desc	ription		Date	Verification	1	QC Inspector
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Equip/Tooling															3
Operator															· · · · · · · · · · · · · · · · · · ·
Material											-				,•
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Landi	ng G	iear				General									
		Bending				Bend		Grain		Γ		Ovalized	[Pressure/Forced
	П	Centre No	ot Concer	ntric to (o/s 🗀	BOM/Route	П	Hardwa	ire			Over/Under	tolerance		Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Monday, December 24, 2012 11:09:46 AM

Page 1

Work Order ID:

94907

Parent Item:

D3933-1

Parent Item Name:

Aft Wall Protector

Start Date: 12/24/2012

Required Date: 1/3/2013

Start Qty: 3.00

Required Qty: 3.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SI	HEET	Purchased	No			100	sf	555.0613	7.01	21.03	24, 313-1-1	3	
				Location		Loc Qty	<u>Loc</u>	Code			-		
				MAT019		555.0613							
				1218	803	555.0613			17-15	803	(3	1	

			DQA:	Date:	
ICD.	Vos. / No.	WORK OPDER NON-CONFORMANCE / LIDDATE	<u></u>		

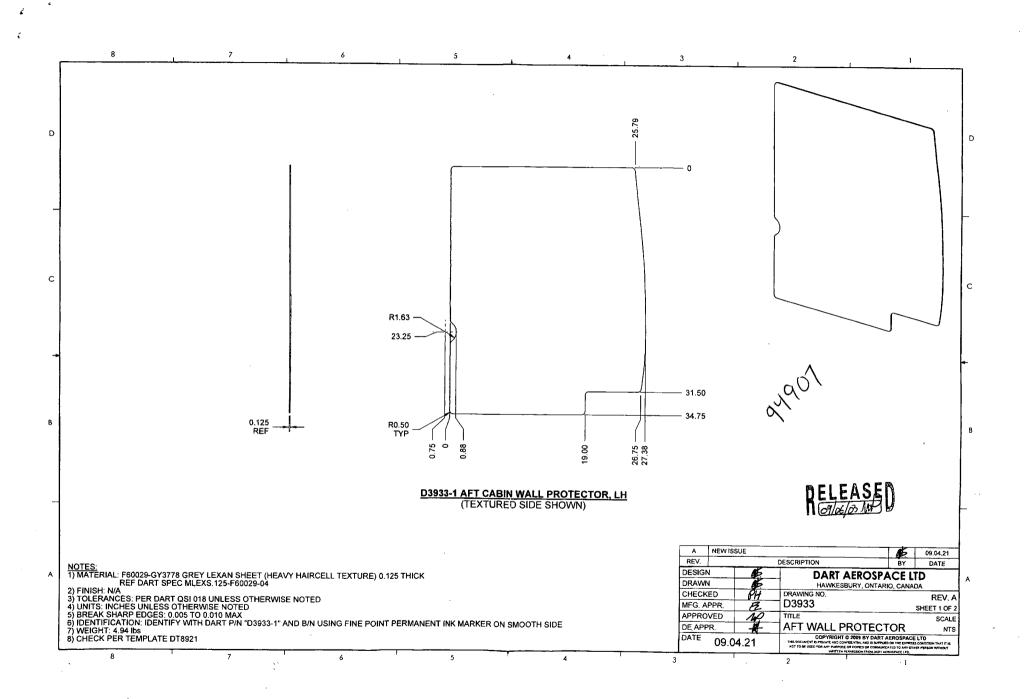
NCR: Y	Yes	/ No			:	WORK ORDER NON-C	JON	NFORI	MANCE / UPI		QA Closed:	Date	:		
Work Orde	or.					DISPOSITION				AGAINST DEI	DEPARTMENT/PROCESS				
Part N	. No					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other		
NCK I	١٠٠.					Work Order opdate	j		carge rab[]	Composite		- Jupplier _			
Root					1	ption of work order update	1	nitial		tion	Sign &				
Cause		Date	Step	Qty	. (or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector		
Doc/Data	Ш														
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Training	-						•								
Unapproved	H						İ								
			·	<u> </u>	L	F	AUL	T CATE	GORY		L	<u> </u>			
Landi	ng G	Gear				General			·· ·						
		Bending				Bend		Grain			Ovalized		Pressure/Forced		
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure		
		Cracks				Broken/Damaged		Inspect	on Incomplete		Part Incorred	ct	Weld		
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled		
		Cuffs				Contamination		Mainte			Part Moved				
		Heat Trea	it			Countersink	\perp	Mislabe			Positioned V		_		
		Inspection		Tube		Cut Too Short	<u>_</u>	Misrea	t		Power Loss/	'Surge	Other		
		Ripples in			<u> </u>	Drill Holes		Offset							
		Torque W			n L	Drawing	L	4	Calibration				·		
		Turning S	equence		1	Finish		Out of	Sequence						

Outside Dimensions

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Wave/Twist in Tube

Folio



DQA:	Date:	•

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

								-		QA Closed:	Date	2:
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
					Rework			kid-tube	Crosstube]	Water Jet	Engineering
Part N	o				Scrap			achining	Small Fab	4	d. Eng. Coor.	Quality
NCR N	o			<u></u>	Use-as-is Work Order Update	1 n		forming arge Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	Initia	al	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												· ·
Setup												
Other							l					
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Landin	g Gear				General					_	_	
	Bending				Bend	Gra	ain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	Har	dware			Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	pection	n Incomplete	L	Part Incorre	ct L	Weld
	Crushed/	Crimped.			Burrs	Inst	ructio	ns Incomplete	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Ma	inten	ance		Part Moved		
	Heat Trea	at			Countersink	Mis	labele	d		Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short	Mis	read			Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes	Offs	set					
	Torque W	/aves in E	Extrusio	n [Drawing	Out	t of Cal	libration	•			
	Turning S	equence			Finish	Out	t of Sec	quence				
	Wave/Tw	ist in Tul	oe .		Folio	Out	tside D	imensions				

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DART AEROSPACE LTD	Work Order:	94907
Description: Aft Cabin Wall Protector, LH	Part Number:	D3933-1
Inspection Dwg: D3933 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	.80	2		T 1301	
19.00	+/-0.030	19.00	3		5	
26.75	+/-0.030	26.75	Λ		7	77 4894
27.38	+/-0.030	27.38	n		-	
34.75	+/-0.030	34.74	1		7	·r ·nam
31.50	+/-0.030	31.50	n		7	
25.79	+/-0.030	75.79			ī	
0.125	+/-0.010	1380	ス		VREL	. !
23.25	+/-0.030	23.05	a		7	
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Measured by:	IB	Audited by:	2/5 2.89	Prototype Approval:	N/A
Date:	13-1-3	Date:	13.1.3	Date:	N/A

Rev	Date	Change	Revised _s by	Approved
Α	09.06.22	New Issue	KJ 944	AX